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DART AEROSPACE LTD	Work Order:	24297
Description: Arm	Part Number:	D2802-2
Dwg: D2802 rev.A	Qty:	6

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	JL	05/09/15	6
2	METAL	Cut blanks 15.800" long 17.800" Material: 6061-T6 bar 6.00" x 0.50" Batch: M18/63	JL	05/09/15	6
3	HAAS	Machine as per folio FA101	JL	05/09/20	6
4	CNC-CELL	Counter sink .375 dia as per dwg	JG	05/09/21	6
5	QC	Inspect Level 2	JL	05/09/20	6
6	QC	Inspect Level 8	JG	05/09/25	6
7	METAL	Tumble & Deburr NO sharp edges.	JNL	05/09/27	6
8	QC	Inspect Level 5	JNL	05/09/27	6
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	N/A		
10	STORES	Identify and stock	JL	05/09/27	6
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: 44.34 \$ 45 05/09/29 6 48.42	JL	05/09/28	6

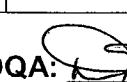
Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	02.03.18

RELEASED

02/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	2	Change Blank Size.	JMP			JB QSI42	18 05.09.27
05.09.19	9	Parts going directly from CNC to welding onto steps D412-630-014	JP	05.09.21	6		J 05.09.27

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.09.19	3	- 1 part scrap did not machine the full profile - error on work order	JB QSI42	- scrap and replace	JL	JB 05.09.20	JB QSI42	18 05.09.20
05.09.19	3	Pivot hole is 0.508" when machined	JP 05.09.19	OK to machine hole $0.507^{+0.001}_{-0.001}$	JP 05.09.27	JP QSI42	JP 05.09.19 per QSI42	18 05.09.27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 
 NOTE: Date & initial all entries

Date: 05/09/28
 QA: N/C Closed: _____ Date: _____

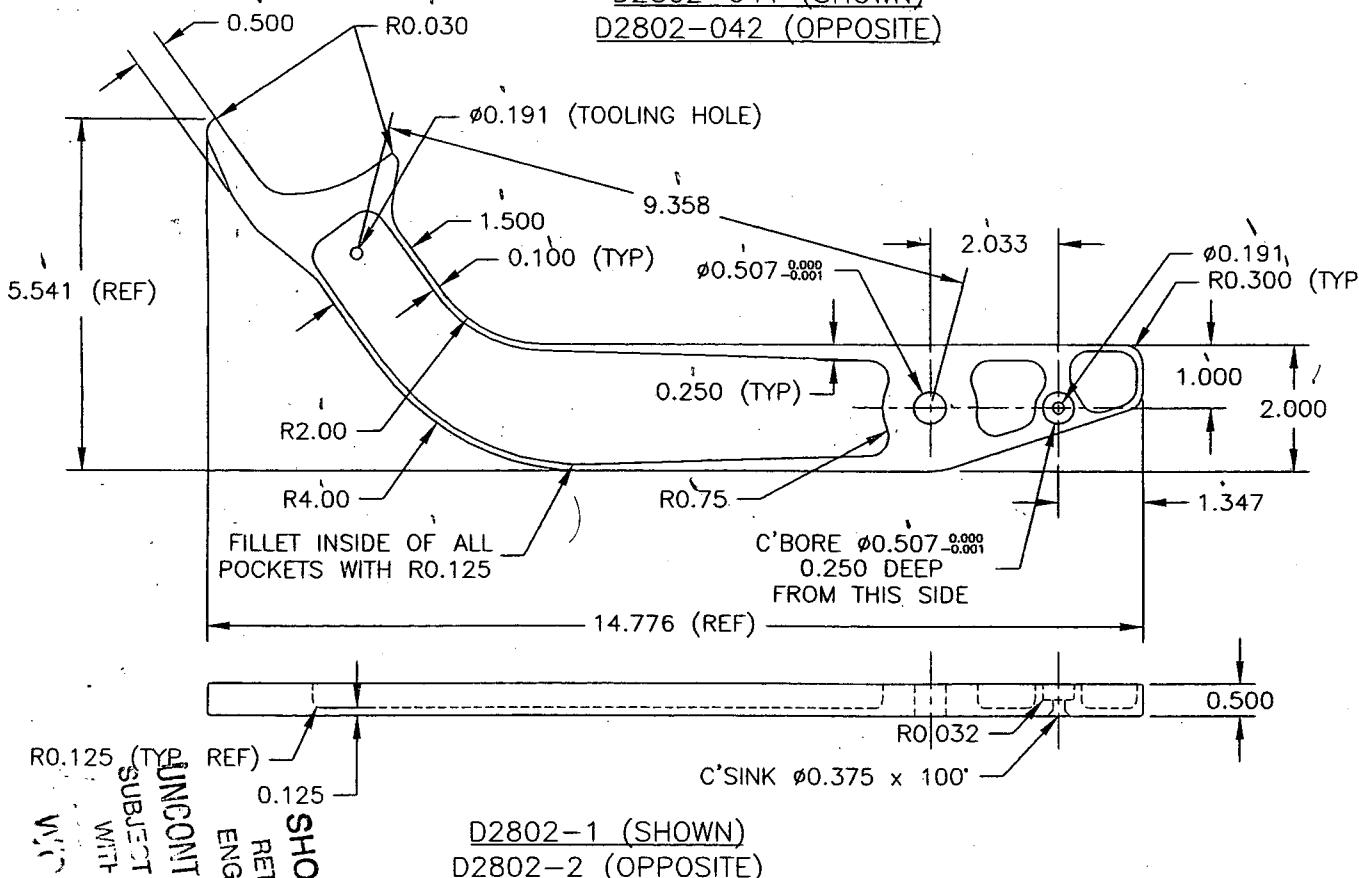
DARTGA COPY
SUEO

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
G	G	DRAWING NO.	REV. A
DATE		D2802	SHEET 1 OF 1
00.11.03		TITLE	SCALE
		ARM	1:3

A	00.11.03	NEW ISSUE
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RELEASED
00.11.13

PRESS FIT D2808 SPACER (1)

USE D2802-1 FOR D2802-041
USE D2802-2 FOR D2802-042**D2802-041 (SHOWN)
D2802-042 (OPPOSITE)**

MACHINED PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
MACHINING
TOOLING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
W/ ORDER
24/2/02

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 15, 2005
10:56 am

Work Order No : 0024297
 Project Name : D2802-2
 Project For : WK539
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2802-2
 Description : Arm
 Manufactured : Yes
 Amount Req'd : 6
 Amount Done : 0
 Start Date : 09-15-05
 Est Finish Date : 09-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART'AEROSPACE LTD	Work Order:	24297
Description: CRM	Part Number:	D2802
Inspection Dwg: A2802 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	J.L	Audited by:	E.P	Prototype Approval:	
Date:	05.09.19	Date:	05/09/29	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Chris Provencal

From: "David Shepherd" <davids@dartaero.com>
To: "Chris Provencal" <chrisp@dartaero.com>
Sent: September 19, 2005 5:19 PM
Subject: Re: D2802-1/-2

This is an acceptable deviation. I think it would be a good idea to update the drawing as you proposed for all future parts.

David

----- Original Message -----

From: Chris Provencal
To: David Shepherd
Sent: Monday, September 19, 2005 3:04 PM
Subject: D2802-1/-2

They are machining D2802-1/-2 arms. The pivot hole is now $0.507+0/-0.001$. They are getting 0.508. The tool program is cutting 0.507 and it's ending up 0.508. They'd have to get Jean-Luc to change the program (not here now). Would a dimension of $0.507+0.001/-0.001$ be allowable?

Sincerely,
Chris Provencal

DART Aerospace Ltd.

Email...chrisp@dartaero.com
Phone...613-632-3336
Fax.....613-632-4443